

Split 2

DART AEROSPACE LTD	Work Order:	22711 B
		D3372-041
Description: Custom W/O collective for AS350	Part Number:	D3372-041
	Keyed:	<input checked="" type="checkbox"/> Alike <input type="checkbox"/> Unlike
Dwg: D3372 Rev. A1 & IIN-D350-740 page 6		3
Ref: N/A		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	JA	05.03.14	8
2	ST	Remove D3372-041 Collective Disabling Kits from Stores. Qty Part Number Description Batch D3372-041 Collective Disabling Kit B2216713	JA	05.03.14	8
3	GA	Open the bag and remove D3372-041 Collective Lock Assembly. Disassemble Cam mechanism on D3373-9 Lock assembly.	JA	05.05.04	8
4	CM	Rework collective D3372-5 & D3372-3 as per Dwg D3372. Deburr.	JA	05.05.05	8
5A	GA	Modify 5/16" WC SS flat washer as per Dwg. D3372. Deburr. N/A			
6	GA	Assemble Cam mechanism as per Dwg D3372. Using the key, ensure disconnect/lock works properly, and the key can be removed in the lock/open position. D3373-1 KA / B22715	SB	05/05/06	4
7	QC5	Inspect work to Step 6	JA	05.05.06	3
8	WS	lock shaft with thick square washer. Using the disconnect/lock works properly, and the key can be lock/open position as per Dwg D3272.	PD	05.05.06	3
9	QC9/5	Step 8	u	05.05.06	3
10	GA	Assemble D3372-051 using 1/4"-20 socket head cap screw and washers as per Dwg IIN-D350-740. Identify as D3372-041 & attach keys	SB	05/05/06	3
11	QC5	Inspect work to Step 10	u	05.05.06	3
12	ST	Repack D3372-041. Ensure batch and key number matches with the bag.	CL	05/05/06	3
13	AC	Cost / part: 56.84	Suc	05.05.20	J
14	DC	Close W/O 56.84 Inspect Level 21	JA	05.05.06	3

(Note: Attach a copy of Custom W/O to each of the W/O's listed in Step 2 above)

5B	FP	1 Traveler cont Rec'd as per W/O 4.3 (5.10)	1 ml	05.05.06	8
D3371-041 Key Numbers			D3372-041 Key Numbers		
			C 4.20 A	X 3	

Rev	Date	Change	Revised By	Approved
A	05.03.14	New Issue	KJ/RF	

6 050506 one scrap during tech webbing

U

Key alike

C420A

3

D3372-041

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-05-06	8	collective body D3372-053 Scraped during track welding. Grounded out through the lock melting the part Qty 1	RF 05.05.10	Scrap & destroy	SB 05/05/06	J 05-05-06	RF 05.05.10	J 05-05-06

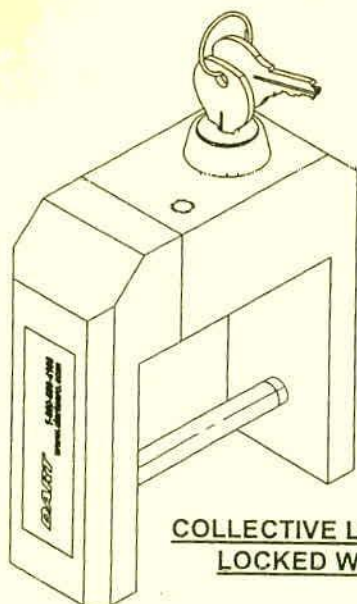
Part No: D3372-041 PAR #: _____ Fault Category: _____ NCR: Yes No (X) DQA: (X) Date: 05-05-11

NOTE: Date & initial all entries

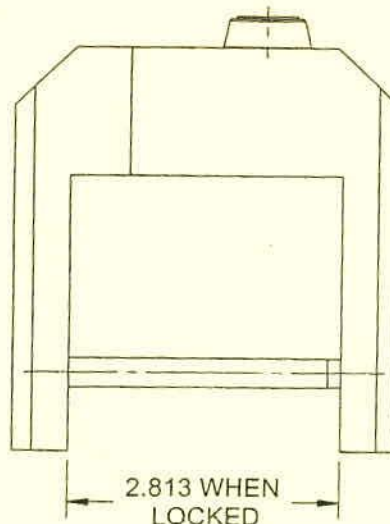
QA: N/C Closed: _____ Date: _____



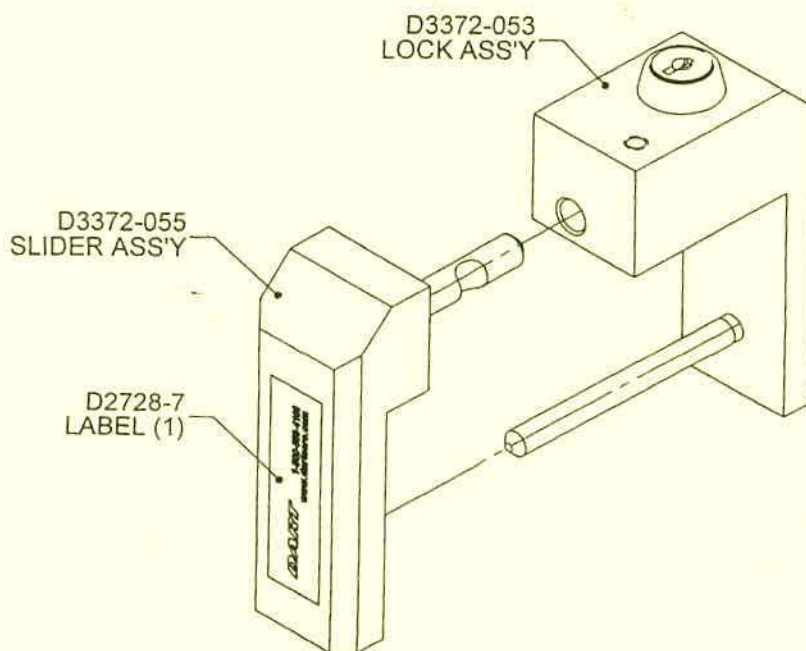
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3372	REV. B SHEET 1 OF 8
DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2
A	05.01.10	NEW ISSUE	
B	05.02.23	REDESIGN FOR STANDARD 1/4 TURN LOCK, D3369-5 SUPERCEDES D3372-11 (OBSOLETE)	



COLLECTIVE LOCK SHOWN
LOCKED WITH KEYS



2.813 WHEN
LOCKED



D3372-051 AS350 COLLECTIVE LOCK ASS'Y

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

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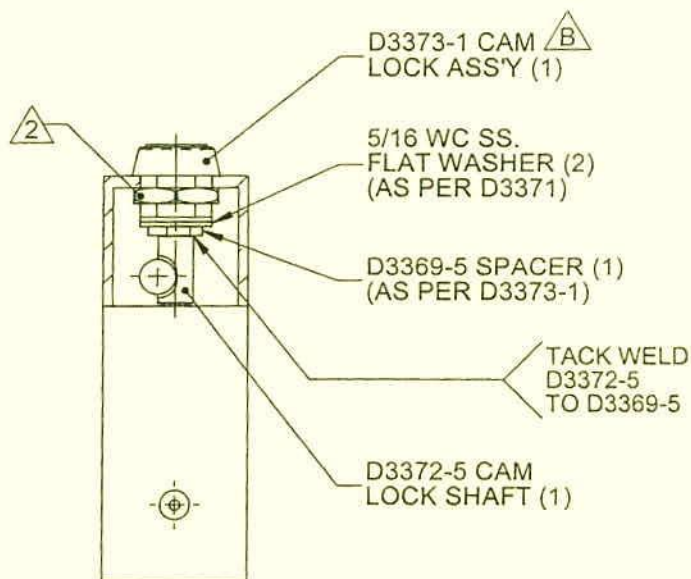
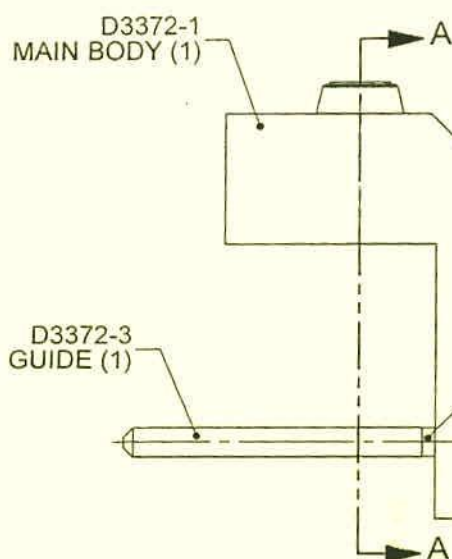
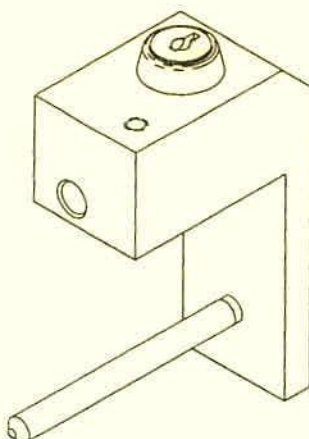
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:2

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SECTION A-A

D3372-053 LOCK ASS'Y

NOTES:

- 1) WELD PER DART QSI 004
- 2) APPLY THREADLOCKER LOCTITE 262 ON THREADS

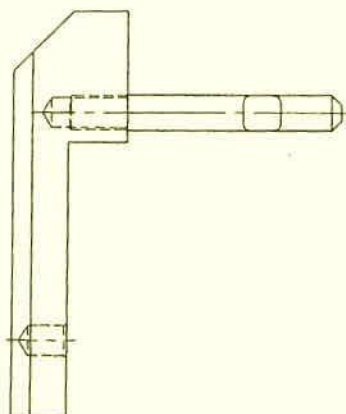
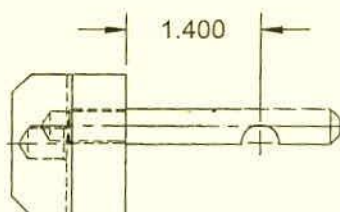
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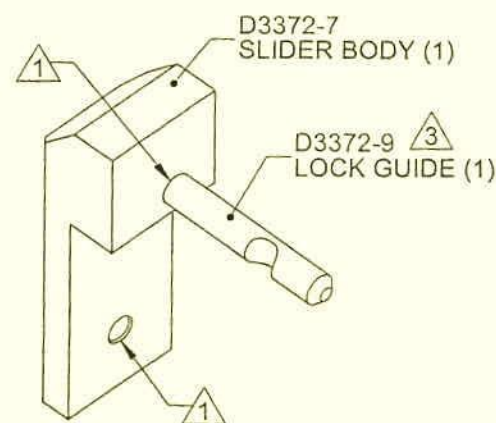
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D3372-055 SLIDER ASS'Y

NOTES:

- 1) COVER INSIDE HOLES AND D3372-9 PRIOR PAINTING
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) APPLY THREADLOCKER LOCTITE 262 ON D3372-9 THREADS PRIOR ASSEMBLY
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

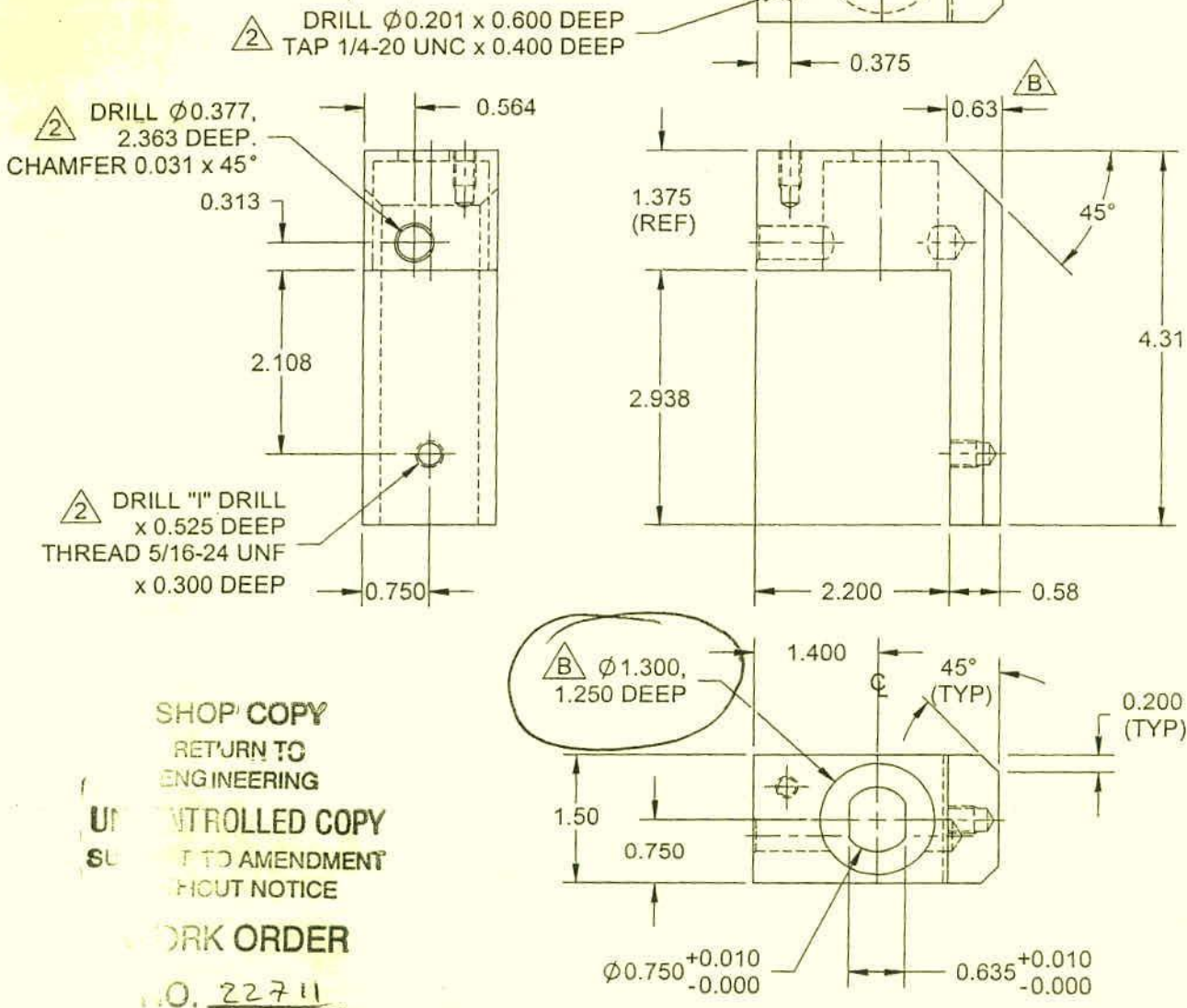
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DATE 05.02.23	TITLE COLLECTIVE LOCK	SHEET 4 OF 8 SCALE 1:2	

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D3372-1 MAIN BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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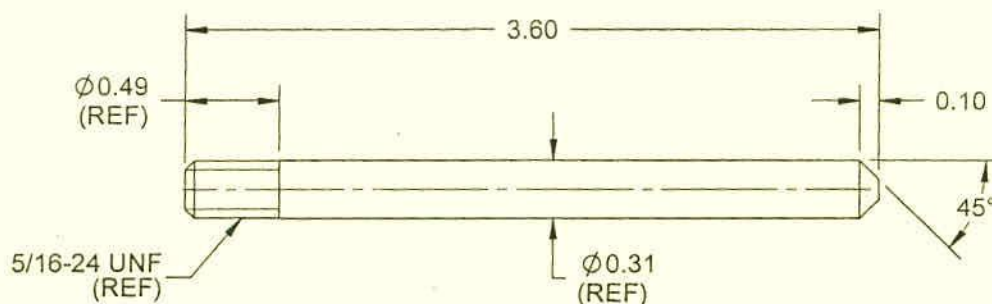


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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 1:1

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D3372-3 GUIDE

NOTES:

- 1) MATERIAL: AN5-42A BOLT MODIFIED AS SHOWN.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

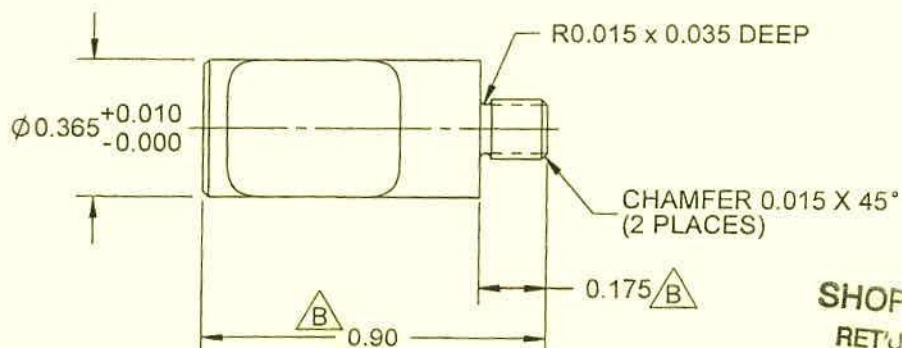
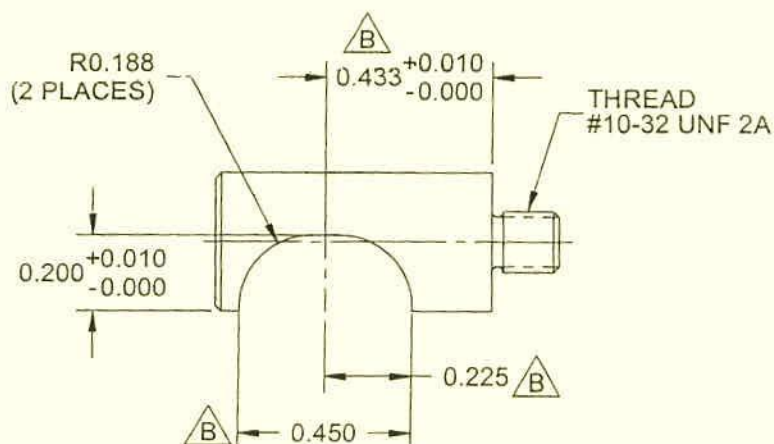
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DATE 05.02.23		TITLE COLLECTIVE LOCK	SCALE 2:1

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D3372-5 CAM LOCK SHAFT

NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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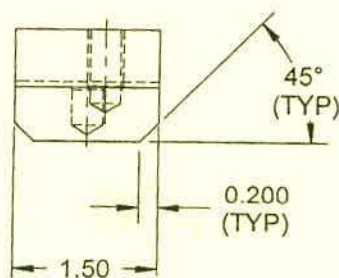
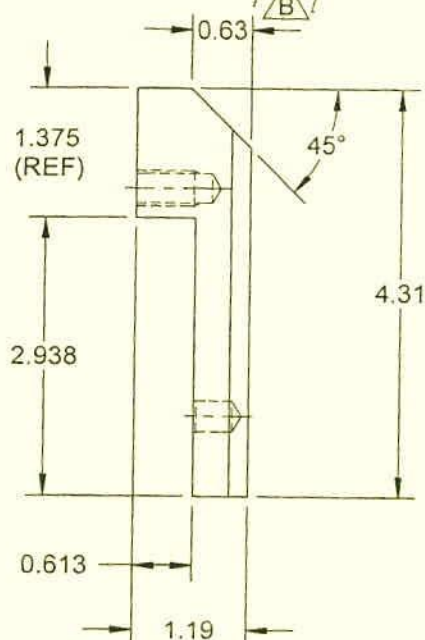
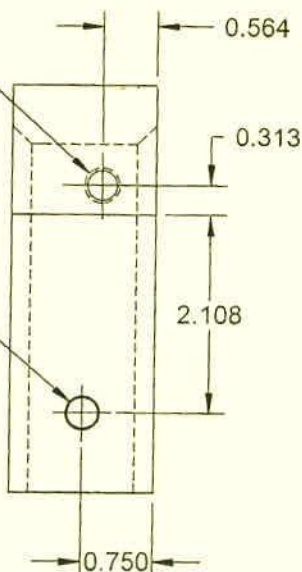
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DATE 05.02.23	TITLE COLLECTIVE LOCK		SCALE 1:2

DRILL $\phi 0.332$
("Q" DRILL) x 0.881 DEEP,
THREAD 3/8-24 UNF x 0.600 DEEP

DRILL $\phi 0.323$
("P" DRILL) x 0.500 DEEP
CHAMFER 0.030 x 30°



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D3372-7 SLIDER BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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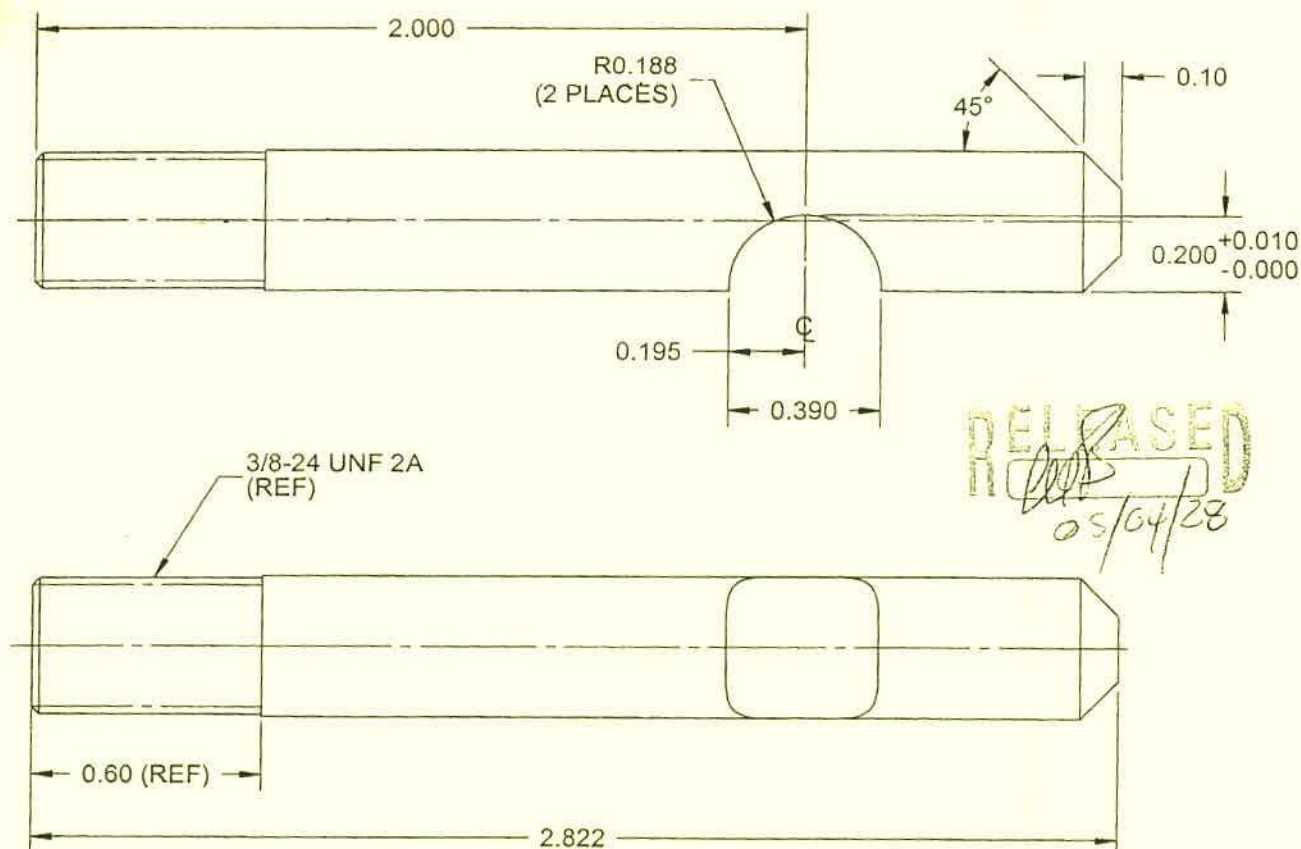
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D3372-9 LOCK GUIDE

NOTES:

- 1) MATERIAL: AN6-36A BOLT, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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MOVE THE COLLECTIVE
CONTROL STICK PRIOR
TO THE INSTALLATION OF
D3372-051 OR D3400-051
COLLECTIVE LOCK
ASSEMBLY

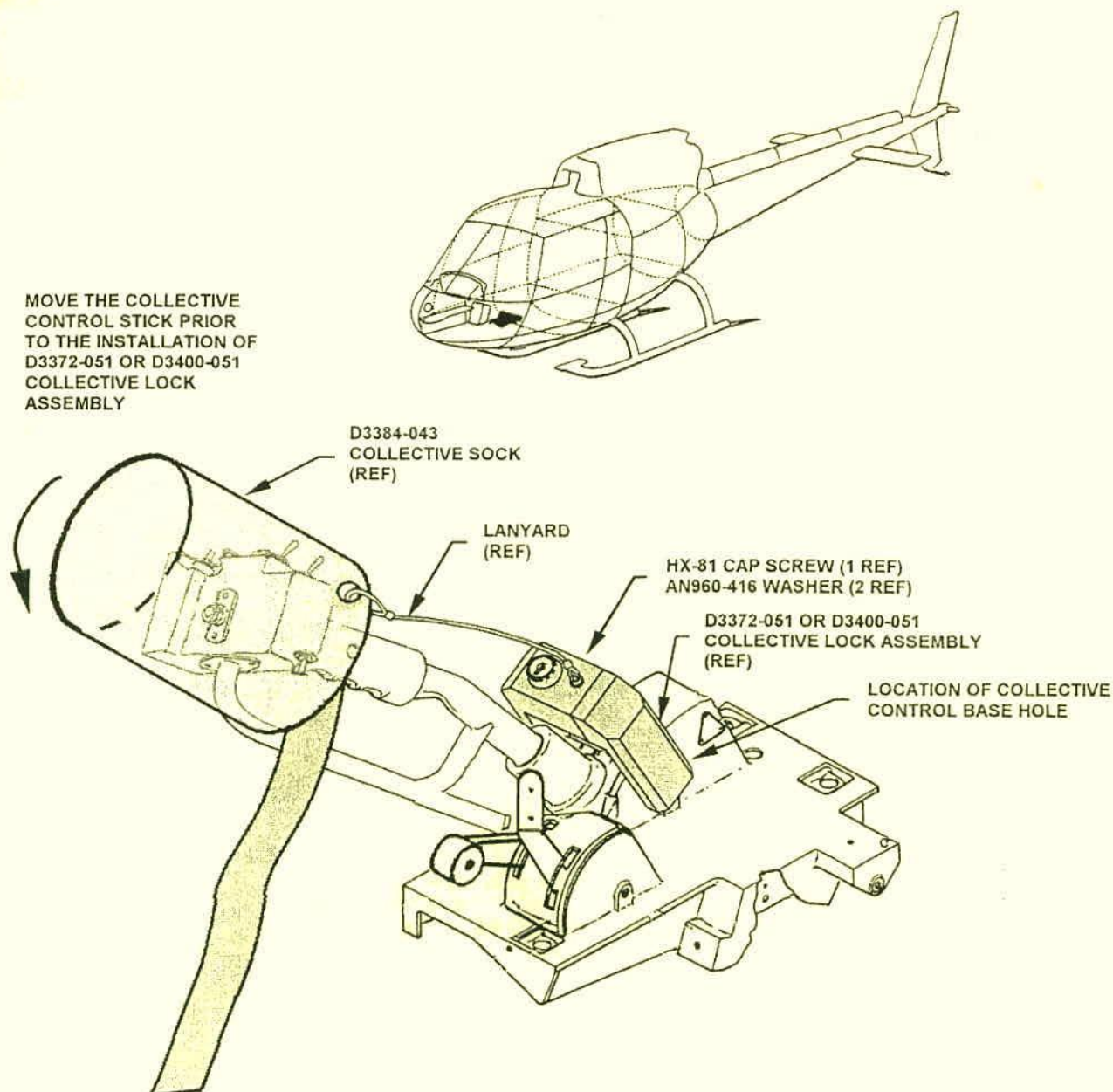


Figure 2– Location of D3372-041 or D3400-041 Collective Disabling Kit

